

Work Order ID 70700

Monday, June 13, 2011 1:37:47 PM



Page 1

Item ID:	D3067-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	End Plate					
Start Date:	6/13/2011	Start Qty: 60.00		Cust Item ID:		
Required Date:	6/20/2011	Req'd Qty: 60.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	11-06-13	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3067	Rev A								

100		0.00							
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Waterjet
FLOW CNC Waterjet
5052-063

FLOW WATER JET

Memo

1-Cut as per Dwg D3067
Dwg Rev: A
Prog Rev: A
2-Deburr if necessary

0.00

11-6-15

110		0.00							
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QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

11-6-15

120		0.00							
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QC
Quality Control

QC8- Inspect parts - second check

Memo

0.00

5/10/15

count

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70700

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Item ID: D3067-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: End Plate					
Start Date: 6/13/2011	Start Qty: 60.00		Cust Item ID:		
Required Date: 6/20/2011	Req'd Qty: 60.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00				90			
Brake NC	Memo	0.00	SB 11/06/15						
Brake NC	Bend as per Dwg D3067								
140 	QC5- Inspect part completeness to step on W/O	0.00				center			
QC	Memo	0.00	SB 11/06/15			90			
Quality Control									
150 	Identify as per dwg & Stock Location: <u>W7</u>	0.00				90			
Packaging	Memo	0.00	11-06-16						
Packaging	*** STOCK IN STEP CELL ***								

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NOTE: Date & initial all entries

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Item ID: D3067-1

Accept



Setup Start



Revision ID:

Stop



Item Name: End Plate

Start Date: 6/13/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/20 [Signature]
MS
11-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 1:37:57 PM

Page 1

Work Order ID: 70700

Parent Item: D3067-1

Parent Item Name: End Plate



Start Date: 6/13/2011

Required Date: 6/20/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: ☐ 03.01.21 Remove step 6 (Deburr) KJ
IPP Rev:B Now on Water jet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063 		Purchased	No			100	sf	91.5000	0.0625	3.947368	61		
5052-H32 .063 Sheet													
				<u>Location</u>				<u>Loc Qty</u>					
				MAT022				91.5					
				114322				91.5					
										<u>114322</u>			

B1-6-15

90

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Dart Aerospace Ltd

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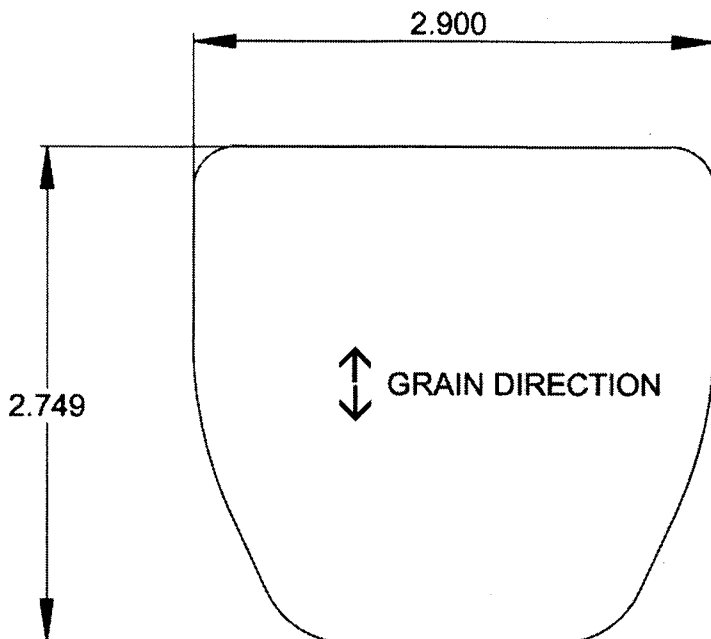
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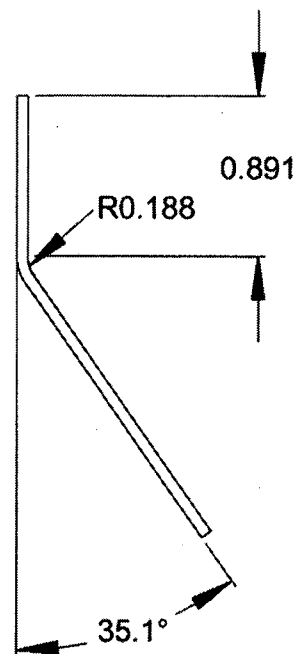


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70700 *pl 11-06-13*

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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